



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G00232-3G-PO

Job Sheet 198912



Part No: RBW6305G00232-3G-PO **Job Qty:** 2 pcs

Part Name: Gimbal Torque Tube Bushing Installer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 10/4/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6305G00232-3G Rev 2 IPP Rev A 18.11.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	2 pcs	10/4/19		0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	2 pcs	10/4/19		0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S217802



Part: RBW6305G00232 - 3G

Job No: 198912

Serial No/Batch: S217802

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 09/27/19

9/7/2019-

[Dart Hawkesbury] Job Sheet - Lussier, Patrick

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	10/4/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
					QC 6 - 40	9-89
					QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	2 pcs	10/4/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	DAS
					Packaging 3 - 35 - B4B	21
					Packaging 3 - 36 - B4B	9-89
140 QC 21 - SA	2 pcs	10/4/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	

DAS
61
9-89

DAS
28
9-89

DAS
21
9-89

OCT 03 2019

Part Op 100 - Issue P/O to ARROW TECH MACHINE WORKS ; P/O 18044221 -Manufacture RBW6305G00232-3G as
 Descriptions: per DWG. -Certificate of Conformity is required
 110 - Certificate of Conformity is required
 120 - QC6- All purchased or subcontracted products
 130 - Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

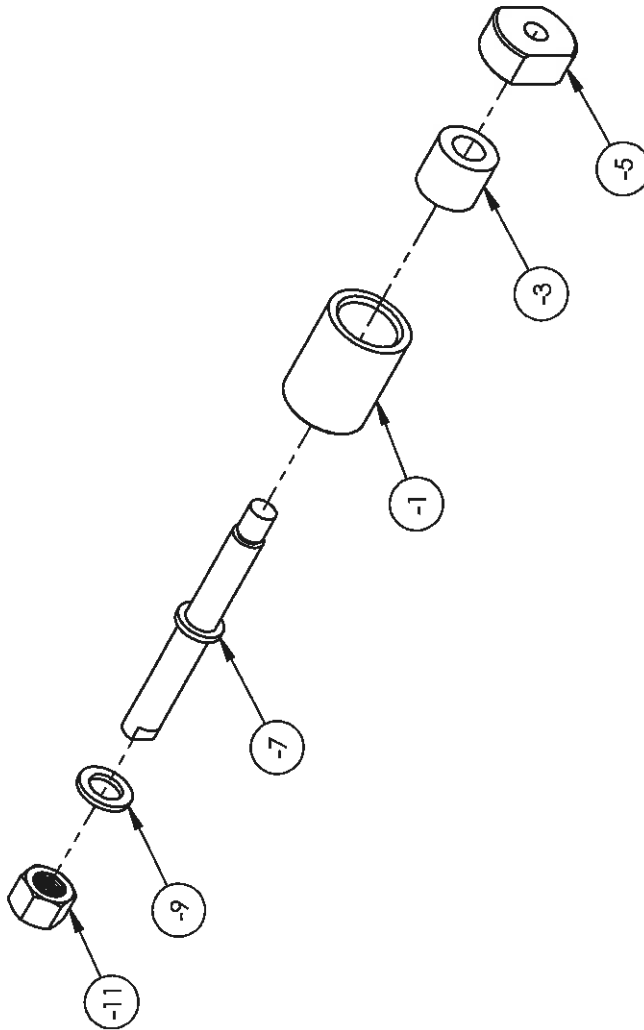
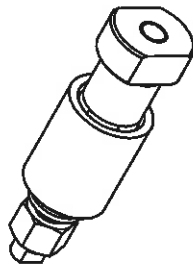
x2 

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBW6305G00232-3GP	Gimbal Torque Tube Bushing Installer	2 Ea (1 ea)	100-Purchasing	5217797
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6305G00232-3GP	2	0	0
Part Specifications				
Specifications could not be found.				

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
A		BROKE OUT INTO INDIVIDUAL TOOL FROM KIT RBW6305G00132-3G.	4/7/2011	RJC
1		-3 CHD I.D. ADDED TOLERANCE WAS $\varnothing.379 \pm .005$ - .000. -7 CHD O.D. ADDED TOLERANCE WAS $\varnothing.375 \pm .005$ - .000.	5/3/2013	CFS
2	15-0292	-1, -3, -5 CHD MATERIAL CALL OUT WAS 4140 Q&T / 4142 Q&T. -7 CHD MATERIAL CALL OUT WAS 4140 Q&T / 4142 Q&T. CHD DIM WAS $\varnothing.317 \pm .030$ IS .05 WAS .040 IS .04.	9/10/2015	RJC
				JAG



NOTE:
ALSO SOLD WITH KIT RBW6305G00132-3G.

DART AEROSPACE		GIMBAL TORQUE TUBE BUSHING INSTALLER		REV 2	
TITLE		DWG NO. RBW6305G00232-3G		DRAWN BY: PERRITT	
MATERIAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm \frac{1}{16}$ DECIMALS $\pm .01$ ANGLES $\pm .5^\circ$		APPROVED: <i>D. West</i>	
PG.		B/O INFORMATION OR SPECIFICATIONS		HEAT TREAT FINISH SPEC	
2		4140 Q&T / 4142 Q&T		1. BREAK ALL SHARP EDGES .015 x 45°	
3		4140 Q&T / 4142 Q&T		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
4		4140 Q&T / 4142 Q&T		USED ON MODEL	
5		4140 Q&T / 4142 Q&T		AGUSTA	
1		STEEL		DATE 4/7/2011	
1		STEEL		SCALE 1:1	
1		3/8-24 UNF AN315-6		SHEET 1 OF 5	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044221



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB044221

PO Date: 8/7/19

Due Date: 10/4/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	198905	RBW6005G01831-3Gp			Dial Indicator Tail Rotor Support REV 3	Firmed	-	10/4/19	3 pcs	0 pcs	3 pcs	\$1,141.25/pcs	\$3,423.75
2	198908	RBW6005G00531-3GP			Jack Screw REV 2	Firmed	-	10/4/19	6 Ea	0 Ea	6 Ea	\$133.00/Ea	\$798.00
3	198909	RBW6005G00631-3GP			Jack Screw REV 2	Firmed	-	10/4/19	6 Ea	0 Ea	6 Ea	\$133.00/Ea	\$798.00
4	198911	RBW6205G00432-3Gp			Main Rotor Pitch Control Link Adjustment Tool REV 5	Firmed	-	10/4/19	3 pcs	0 pcs	3 pcs	\$2,030.50/pcs	\$6,091.50
5	198912	RBW6305G00232-3GP			Gimbal Torque Tube Bushing Installer REV 2	Firmed	-	10/4/19	2 Ea	0 Ea	2 Ea	\$708.75/Ea	\$1,417.50

Grand Total: \$12,528.75



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PURCHASE ORDER
POHB044221



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Plex 8/7/19 1:42 PM dart.lussier.patrick



Packing Slip Number	714
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Date: 9/20/2019.

Ship Via: **FED-EX**

PC#: HB044221

Bill to: DART AEROSPACE
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

RECEIVED
SEP 24 2019
DART AEROSPACE LTD

Aug
J. M. L.

1. *Chlorophyll a* (Chl *a*)
 2. *Chlorophyll b* (Chl *b*)
 3. *Chlorophyll c* (Chl *c*)
 4. *Chlorophyll d* (Chl *d*)
 5. *Chlorophyll e* (Chl *e*)
 6. *Chlorophyll f* (Chl *f*)
 7. *Chlorophyll g* (Chl *g*)
 8. *Chlorophyll h* (Chl *h*)
 9. *Chlorophyll i* (Chl *i*)
 10. *Chlorophyll j* (Chl *j*)
 11. *Chlorophyll k* (Chl *k*)
 12. *Chlorophyll l* (Chl *l*)
 13. *Chlorophyll m* (Chl *m*)
 14. *Chlorophyll n* (Chl *n*)
 15. *Chlorophyll o* (Chl *o*)
 16. *Chlorophyll p* (Chl *p*)
 17. *Chlorophyll q* (Chl *q*)
 18. *Chlorophyll r* (Chl *r*)
 19. *Chlorophyll s* (Chl *s*)
 20. *Chlorophyll t* (Chl *t*)
 21. *Chlorophyll u* (Chl *u*)
 22. *Chlorophyll v* (Chl *v*)
 23. *Chlorophyll w* (Chl *w*)
 24. *Chlorophyll x* (Chl *x*)
 25. *Chlorophyll y* (Chl *y*)
 26. *Chlorophyll z* (Chl *z*)
 27. *Chlorophyll aa* (Chl *aa*)
 28. *Chlorophyll ab* (Chl *ab*)
 29. *Chlorophyll ac* (Chl *ac*)
 30. *Chlorophyll ad* (Chl *ad*)
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 85. *Chlorophyll agz* (Chl *agz*)
 86. *Chlorophyll ahz* (Chl *ahz*)
 87. *Chlorophyll aiz* (Chl *aiz*)
 88. *Chlorophyll ajz* (Chl *ajz*)
 89. *Chlorophyll akz* (Chl *akz*)
 90. *Chlorophyll alz* (Chl *alz*)
 91. *Chlorophyll amz* (Chl *amz*)
 92. *Chlorophyll anz* (Chl *anz*)
 93. *Chlorophyll aoz* (Chl *aoz*)
 94. *Chlorophyll apz* (Chl *apz*)
 95. *Chlorophyll aqz* (Chl *aqz*)
 96. *Chlorophyll arz* (Chl *arz*)
 97. *Chlorophyll asz* (Chl *asz*)
 98. *Chlorophyll atz* (Chl *atz*)
 99. *Chlorophyll auz* (Chl *auz*)
 100. *Chlorophyll avz* (Chl *avz*)
 101. *Chlorophyll awz* (Chl *awz*)
 102. *Chlorophyll axz* (Chl *axz*)
 103. *Chlorophyll ayz* (Chl *ayz*)
 104. *Chlorophyll azz* (Chl *azz*)
 105. *Chlorophyll azaa* (Chl *aza*)
 106. *Chlorophyll abz* (Chl *abz*)
 107. *Chlorophyll acz* (Chl *acz*)
 108. *Chlorophyll adz* (Chl *adz*)
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 111. *Chlorophyll agz* (Chl *agz*)
 112. *Chlorophyll ahz* (Chl *ahz*)
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 123. *Chlorophyll asz* (Chl *asz*)
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 125. *Chlorophyll auz* (Chl *auz*)
 126. *Chlorophyll avz* (Chl *avz*)
 127. *Chlorophyll awz* (Chl *awz*)
 128. *Chlorophyll axz* (Chl *axz*)
 129. *Chlorophyll ayz* (Chl *ayz*)
 130. *Chlorophyll azz* (Chl *azz*)
 131. *Chlorophyll azaa* (Chl *aza*)
 132. *Chlorophyll abz* (Chl *abz*)
 133.



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044221

Dated: 9/20/2019

Our Order / Job No: AWT-HB044221 A5

Order Qty: 2

Part Name: GIMBAL TORQUE TUBE BUSHING-INSTALL

Part Number RBW6305G00232-3G

Lot Size: N/A

Ship Date: 9/20/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6305G00232-3G

Rev: 2

Material Size and Type: -1, -3, -5, -7/ 4140 Q&T

Material Specifications: STEEL: ASTM A108, ASTM A29

Heat Treatment: (28-32 RC)

Plating/Finish: ZINC PLATE: ASTM B633 TYPW 1 CLASS 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date:

9/20/19

Signed:

Herman Salt

DAS
61
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com